

Work Order ID 61503

Friday, August 27, 2010 3:31:07 PM



Page 1

Item ID: D3492-043

Accept



Setup Start



Revision ID:

Item Name: Plug Assembly

Stop



Start Date: 8/30/2010 Start Qty: 60.00



Cust Item ID:

Required Date: 9/6/2010 Req'd Qty: 60.00



Customer:

Reference:

Approvals:

Process Plan: MWFDate: 10-8-21

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3492	Rev C

100



Hardinge CNC LATHE SMALL

Hardinge

Memo

Hardinge CNC Lathe Small

1-Turn as per Folio FA632 & Dwg D3492 Dwg Rev: C Folio
Rev: AB

SL 10/08/31

110



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

Quality Control

0.00

SL 10/08/31

120



QC8- Inspect parts - second check

QC

Memo

Quality Control

0.00

SL 10/08/31

(62)

Work Order ID 61503

Page 2

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Cust Item ID:

Required Date: 9/6/2010 Req'd Qty: 60.00



Customer:

Reference:

Approvals: Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



Chemical Conversion Coat per QSI005 4.1

0.00

60

BK 10-8-31.

HandFinish

Memo

0.00

Hand Finishing

140



White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

ML 10 09 01 60

Powdercoat

Memo

0.00

Powder Coating

(Flat End Only) START TIME: 11:30 OVEN
TEMPERATURE: 320° FINISH TIME: 12:00

150



QC3- Inspect Part Finish

0.00

Quality Control

Memo

0.00

ML 10/09/01

60 φ

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Page 3

Item ID: D3492-043

Accept



Setup Start



Revision ID:

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Cust Item ID:

Required Date: 9/6/2010 Req'd Qty: 60.00



Customer:

Reference:

Approvals: Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
Description

160

Identify as per dwg & Stock Location: FP-B

Packaging

Packaging

170



QC

Quality Control

Set Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

0.00

M

10/09/01

60

0

0.00

0.00

10/09/01
J

M
10-9-01

170



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

Quality Control

Picklist Print

Friday, August 27, 2010 3:31:07 PM

Page 1
T

Work Order ID: 61503



Parent Item: D3492-043



Parent Item Name: Plug Assembly

Start Date: 8/30/2010

Required Date: 9/6/2010

Start Qty: 60.00

Required Qty: 60.00

Comments: IPP Rev: A 06.03.21 New Issue JLM

IPP Rev:B 06-08-28 As per Rev B JLM

IPP Rev:C 07-12-06 Rev C dwg DD verified by:EC

IPP Rev:D 08-05-07 add note to count qty DD verified by:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6R0.750		Purchased		No		100	f	20.0695	0.0625	3.947368			

6061-T6 Round Bar .750"



Location	Loc Qty	Loc Code
MAT	20.0527	
115469	20.0527	
MAT012	0.016842105	
112442	0.01684211	

3.95

JL 10/68/31

DART AEROSPACE LTD	Work Order:	61503
Description: Plug	Part Number:	D3492-3
Inspection Dwg: D3492 Rev: C		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	SL	Audited by:	LS	Prototype Approval:	N/A
Date:	10/08/31	Date:	10/08/31	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.07.07	New Issue P/O D3492-043	KJ/JLM	
B	06.10.16	\varnothing 0.750 was \varnothing 0.625	KJ/JLM	
C	08.09.04	Tolerance revised for \varnothing 0.750	KJ/DD	 

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

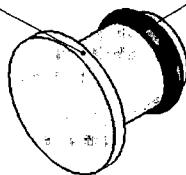
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

D3492-XX PLUG
(SEE TABLE)

NAS1611 PLUG
(SEE TABLE)



61503

D3492-XXX PLUG PARTS LIST

QTY -041	QTY -043	QTY -045	QTY -047	QTY -049	QTY -051	QTY -053	PART NUMBER	DESCRIPTION
X							D3492-041	PLUG ASSEMBLY
	X						D3492-043	PLUG ASSEMBLY
		X					D3492-045	PLUG ASSEMBLY
			X				D3492-047	PLUG ASSEMBLY
				X			D3492-049	PLUG ASSEMBLY
					X		D3492-051	PLUG ASSEMBLY
						X	D3492-053	PLUG ASSEMBLY
1							D3492-1	PLUG
	1						D3492-3	PLUG
		1					D3492-5	PLUG
			1				D3492-7	PLUG
				1			D3492-9	PLUG
					1		D3492-11	PLUG
						1	D3492-13	PLUG
							NAS1611-005	O-RING
				1			NAS1611-007	O-RING
1							NAS1611-010	O-RING
					1		NAS1611-012	O-RING
						1	NAS1611-013	O-RING
						1	NAS1611-015	O-RING
						1	NAS1611-016	O-RING

△ △ △

NOTES:

1) O-RING: POSSIBLE SUPPLIER P/N: NAS1611-XXX OR PARKER 2-XXX

~~UNDER REVIEW~~
CJ.CA 08.11.12
OK NSS 08.11.12

DEO ATTACHED

RELEASED
21.11.16 JPB

C	ADD -049-051-053, CHANGE DRAWING FORMAT	PH	07.10.05
B	ADD -047; UPDATE DIM A FOR -045	PH	06.05.11
A	NEW ISSUE	PH	06.01.04
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>✓</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	<i>✓</i>		
CHECKED	<i>✓</i>		
MFG. APPR.	<i>✓</i>		
APPROVED	<i>✓</i>		
DE APPR.	<i>✓</i>		
DRAWING NO.	D3492	REV. C	SHEET 1 OF 2
TITLE	PLUG	SCALE	2:1
DATE	07.10.05	COPRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE PROPERTY AND IS RELEASED UNDER THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

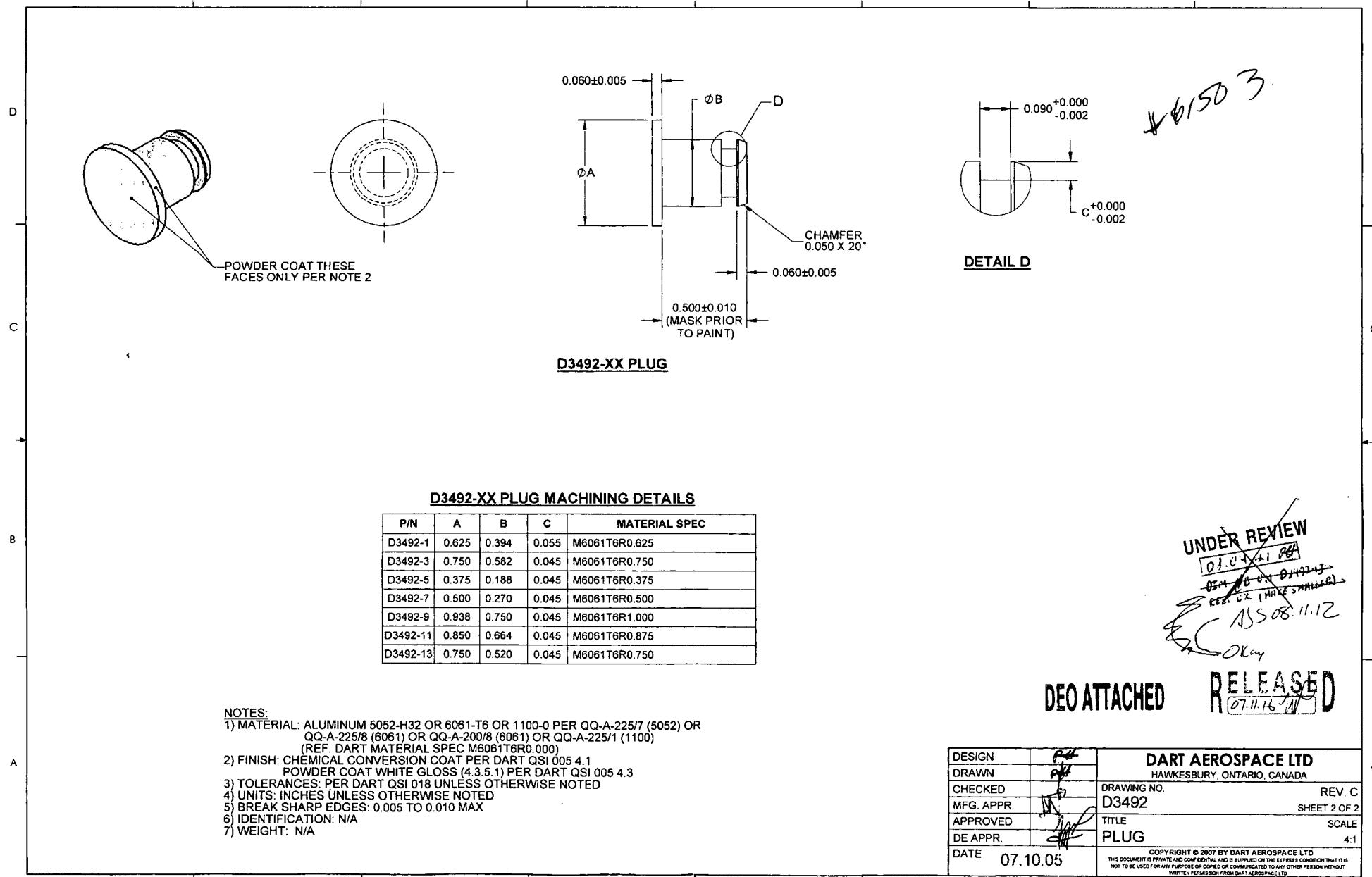
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8 7 6 5 4 3 2 1



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DRAWING NO. D3492	TITLE PLUG	REV. C	DART AEROSPACE LTD ENGINEERING ORDER		D.E.O. NO. D3492-C-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN DATE	AJS 08.11.05	CHECKED <i>✓</i> 08.11.05	MFG. APPR. <i>B</i>	APPROVED <i>MP</i>	DE APPR. <i>✓</i>	DATE	08.11.05 08.11.05

SHEET 2 MODIFY -13 PLUG AS SHOWN:

(F6 150°)

IS:

D3492-XX PLUG MACHINING DETAILS

P/N	A	B	C	MATERIAL SPEC
D3492-13	0.750	0.510	0.045	M6061T6R0.750

WAS:

D3492-XX PLUG MACHINING DETAILS

P/N	A	B	C	MATERIAL SPEC
D3492-13	0.750	0.520	0.045	M6061T6R0.750

RELEASED
08/11/10 MW

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries